

Work Order ID 86927

86927

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Item ID: D2175-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Angle RH
 Start Date: 7/09/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2175	Rev E								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2175								
2024.063	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-7-24

B12-7-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D2175-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle RH

Start Date: 7/09/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 <i>SMB</i> 0.00 <i>12-7-24</i>	<i>DAS</i> <i>16</i> <i>12/17/25</i>			<i>8</i>			
130 *130* Small Fab Small Fab Small Fab	Small Fab Memo Debur Stack	0.00 0.00	<i>NAS</i>						
140 *140* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D2175	0.00 0.00				<i>8</i>			<i>8 12/17/25</i>

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Start Date: 7/09/12 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 7/27/12 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00		DAS 16 12/4/25		8			
Quality Control						-2			
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00				8	76	12-7-26	
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control						8X		12/07/26	

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N900040100

Setup Start *NS1*

Stop *NS2*

6

6

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

180

Packaging

Packaging

Memo

0.00

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

0.00

12/7/26 11

0120726

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Picklist Print

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Page 1

Work Order ID: 86927

Parent Item: D2175-2

Parent Item Name: Angle RH

Start Date: 7/09/12

Required Date: 7/27/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP E04.06.09ReformatKJ/RF
IPP Rev:F 06-04-28 Manufactured on Water Jet JLM
IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

239.8900

0.4722

2.9823156

4,

1812-7-24

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

239.89

119916

67.35

121197

172.54

121197

(8)

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DART AEROSPACE LTD		Work Order: 86927
Description: Angle		Part Number: D2175-1/-2
Inspection Dwg: D2175	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.656	✓		T B1	
R0.35	+/-0.030	.35	✓		R.G	
2.915	+/-0.010	2.916	✓		V B2	
50°	+/-0.5°	50°	✓			
0.300	+/-0.010	.302	✓		✓	
1.050 Pitch	+/-0.010	1.044	✓		✓	
10.500	+/-0.010	10.500	✓		T	
11.550	+/-0.010	11.508	✓		T	
0.550	+/-0.010	.547	✓		✓	
0.900	+/-0.010	.900	✓		✓	
0.063 thick	+/-0.010	.064	✓		✓	
Grain Direction	N/A		✓			
Ø0.128	+0.005/-0.001	.129	✓		✓	
Ø0.172	+0.005/-0.001	.173	✓		✓	

Measured by: B	Audited by: SMB	Prototype Approval:	N/A
Date: 12-7-24	Date: 12-7-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

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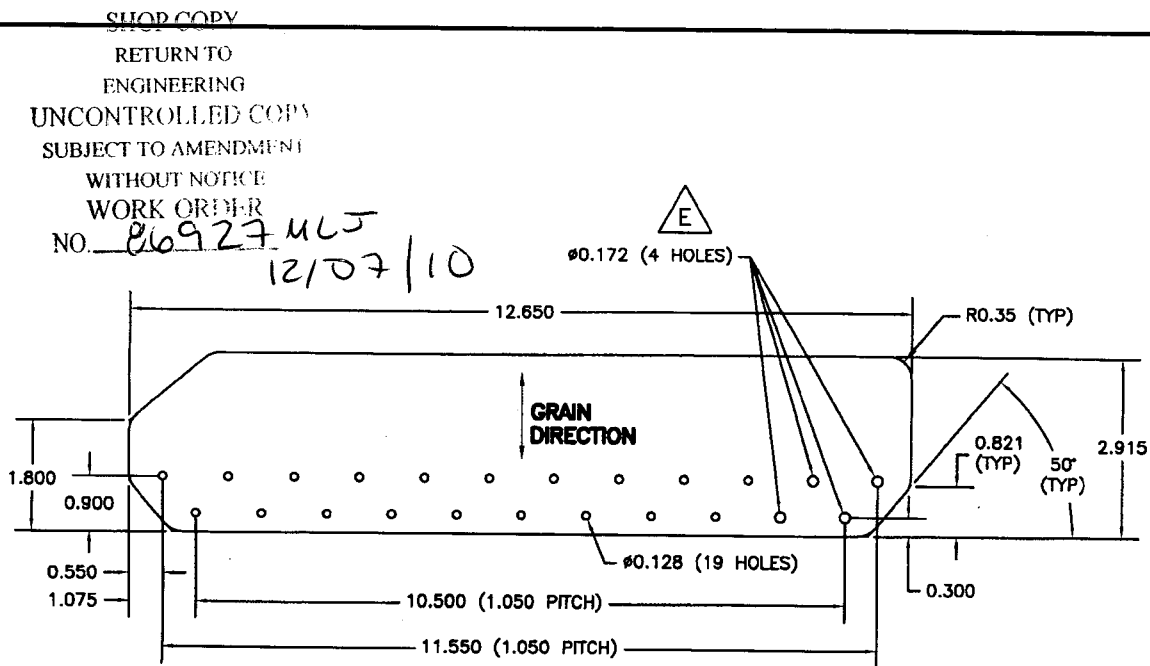
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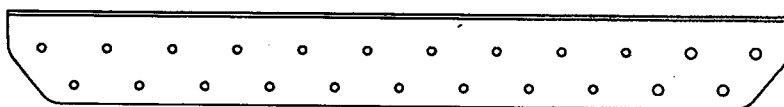


RELEASED
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD	
RF	CE	HAMKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO.	REV. E
DATE 06.09.25		D2175	SHEET 1 OF 1
		TITLE	SCALE
		ANGLE	1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	CHANGED DIMENSION	
C	00.09.11	UPDATE FINISH SPEC	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES	



D2175-1F FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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